Date:

Monday, 28/05/2007 9:11:24 AM

Linda Lacelle

Process Sheet

Customer

Job Number

: CU-DAR001 Dart Helicopters Services

Drawing Name

: 350 STEP END PLATE

Estimate Number

: 32404 : 11015

P.O. Number This Issue

: N/A : 28/05/2007

S.O. No. : NA

Prsht Rev. First Issue

: SMALL /MED FAB Type

Part Number Drawing Number : D267334 : D2673 REV B

: N/A Project Number **Drawing Revision**

: 04/06/2007

Material **Due Date**

Each

Previous Run Written By

Checked & Approved By

Comment

Removed deburr and inspect level 5 NG/EC

Now 6061-T6 06-06-23 JLM Est Rev:D Est Rev:C Now on Waterjet 07-05-28 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6S080

6061-T6 .080 Sheet

FLOW WATER JET

 $\frac{21.808Z = 114 - RLy}{0.1913 \text{ sf(s)/Unit}} \qquad \frac{21.808Z = 114 - RLy}{191310 \text{ sf(s)}}$

Comment: Qty.: 6061-T6 .080 Sheet (M6061T6S080)

Note: 1 Blank makes 2

Material Batch MID4186

27106/61

WATER JET



Comment: FLOW WATER JET 1-Cut as per Dwg D2673

Prog Rev:____



3.0



2-Deburr if necessary

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

SECOND CHECK



Comment: SECOND CHECK

Date:

Monday, 28/05/2007 9:11:24 AM

User:

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 STEP END PLATE

Job Number: 32404

Part Number: D267334

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock Location: 1

FINAL INSPECTION/W/O RELEASE

6.0

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07.06.15

Date: **≸**User:

. .-

Wednesday, 5/16/2007 1:40:40 PM

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Drawing Name

: 350 STEP END PLATE

Job Number

Estimate Number

: 32404

: 11015

: 5/16/2007

Part Number

P.O. Number This Issue

S.O. No. :

Type

: D267334 : D2673 REV B

Prsht Rev.

: NC

Drawing Number

First Issue

: //

Project Number

: N/A

Previous Run

: 25396

Drawing Revision

: B

Material Due Date

: 6/5/2007

100 Um:

Qty:

Each

Written By

Comment

Checked & Approved By

Removed deburr and inspect level 5 NG/EC : Est. C 02:01.14

Now 6061-T6 06-06-23 JLM Est Rev:D

: MACHINED PARTS

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

6061-T6 .080 Sheet

1.0

M6061T6S080

Comment: Qty.:

0.1913 sf(s)/Unit

Total:

19.1310 sf(s)

6061-T6 .080 Sheet (M6061T6S080) Note: 1 Blank makes 2

Material Batch

SHEAR



Comment: SHEAR

Shear blanks: 5.10 X 3.30 +0.000/-0.010 (use off-cuts)

3.0

2.0

HAAS1

HAAS CNC VERTYCAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine per H2673

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Dart Aerosi	pace Ltd
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W/O:		WORK ORDER CF	IANGES					
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #: Fault Category:	NCR:	Yes	No DQ	A:	_ Date: _	
				QA: I	N/C Close	d:	Date:	

NCR: WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B			Verification	Annroval	Ammousel
DATE	STEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	tion	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
				i					
·-									

NOTE: Date & initial all entries

Dăte:

Wednesday, 5/16/2007 1:40:40 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 STEP END PLATE

Job Number: 32404

Part Number: D267334

Job Number:



Seq. #:

Machine Or Operation:

Description:

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart A	Aeros	pace	Ltd
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W/O:	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #: Fault Category:	NC	R: Yes	No DQA	۸:	_ Date: _	
				QA:	N/C Closed	l:	_ Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC	Corrective Action		Section B		1 Section B		Verification	Annroyal	Annewal
DATE	STEP	Section A	Initial Chief Eng	Initial Action Description Sign & Section		Initial Action Description Sign & Section C		Approval Chief Eng	Approval QC Inspector		
					= :						
											

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32404
Description: End Plate	Part Number:	D2673-34
Inspection Dwg: D2673 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X F	irst Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.300	+/-0.010	3308	/		Vern	
2.247	+/-0.010	2.246	/		Veru	
R0.250	+/-0.010	3308 2.246 R0.250			Veru R-6	
				<u> </u>		
			:			
				ATTA MICT.		
-					!	

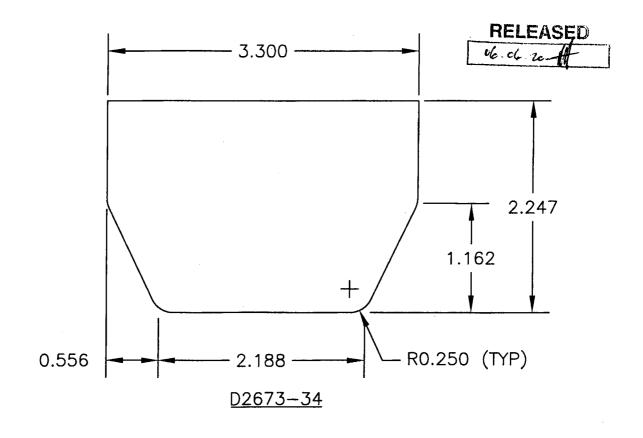
Measured by:	SAV	Audited by:	F6	Prototype Approval:	N/A
Date:	07/06/01	Date:	07.06.01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue	KJ/RF	
В	04.06.15	Remove 1.162, 2.188 & 0.556 dimensions	KJ/JLM , ,	
С	06.06.23	Dwg Rev. changed	KJ/JLM ox	411



ſ	DESIGN B	W 4	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAL	
ľ	CHECK		APPROVED ,	DRAWING NO.	REV. B
١		PH	1	D2673	SHEET 1 OF 1
Ī	DATE			TITLE	SCALE
	06.0	5.29		END PLATE	1:1
	Α		97.05.06	NEW ISSUE	
	В		06.05.29	ADD 6061-T6 MATERIAL	

END PLATE FOR D2244 EXTRUSION CUT AT 34°



NOTES:

1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027)

0.080" THICK (REF DART SPEC M6061T6S.080)

SHOP COPY RETURN TO

5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) ENGINEERING 0.080" THICK (REF DART SPEC M5052H32S.080) UNCONTROLLED COP ARE PER DART OSI 0.18 LINI ESS OTHERWISE MOTICE 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTEDMITHOUT NOTICE

3) ALL DIMENSIONS ARE IN INCHES

4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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